

Date: Wednesday, 21/05/2008 8:48:13 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: INBOARD WINDOW DOUBLER	
Job Number	: 38828		Part Number	: D37001	
Estimate Number	: 13147		Drawing Number	: D3700 PRELIM	
P.O. Number	:		Project Number	: N/A	
This Issue	: 21/05/2008	S.O. No. :	Drawing Revision	: PRELIM	
Prsht Rev.	: NC		Material	:	
First Issue	: 28/04/2008	Type	Due Date	: 05/05/2008	
Previous Run	: 37133		Qty:	(2)	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev:A 08-01-30 new issue DD verified by:				

Additional Product

PROTOTYPE~~**PRELIMINARY ISSUE**~~

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet Comment: Qty.: 0.2984 sf(s)/Unit Total : 0.2984 sf(s) 6061T6 aluminium sheet .080" thick (M6061T6S080) Batch: 107276
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3700 Dwg Rev: PRFL Prog Rev: PRFL 2- Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.05.22	4	Scrap parts that / not good Incorrect material received.	by 08.05.22	Scrap + replace See NCR 08-04-16	See get 4	See get 4	by 08.05.22	08.05.22
				- Rep base on				

NOTE: Date & initial all entries

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6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not required

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

BS 08.05.21

8.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

A 08.05.21 Prototype only

Job Completion



MF 08-06-13

8 7 6 5 4 3 2 1

D

D

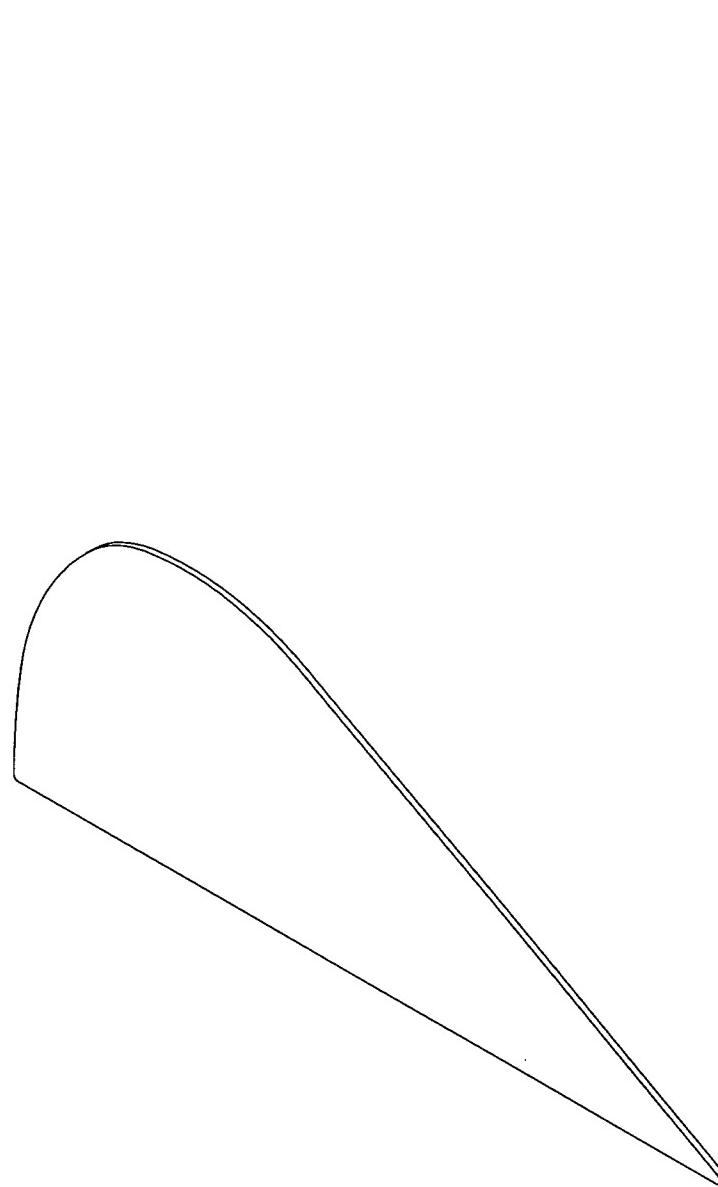
C

C

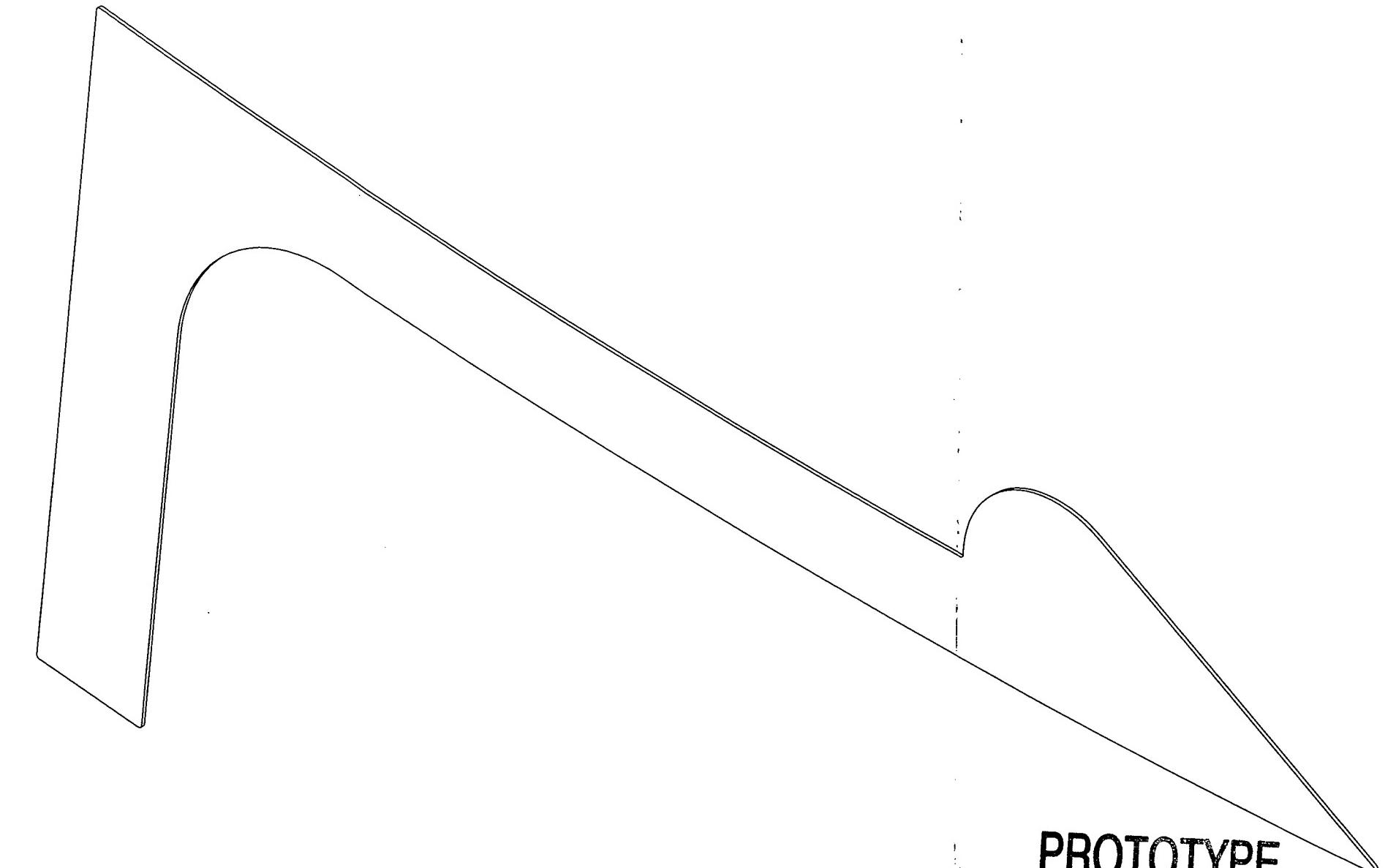
B

B

D3700-1 INBOARD WINDOW DOUBLER



D3700-3 OUTBOARD WINDOW DOUBLER



PROTOTYPE

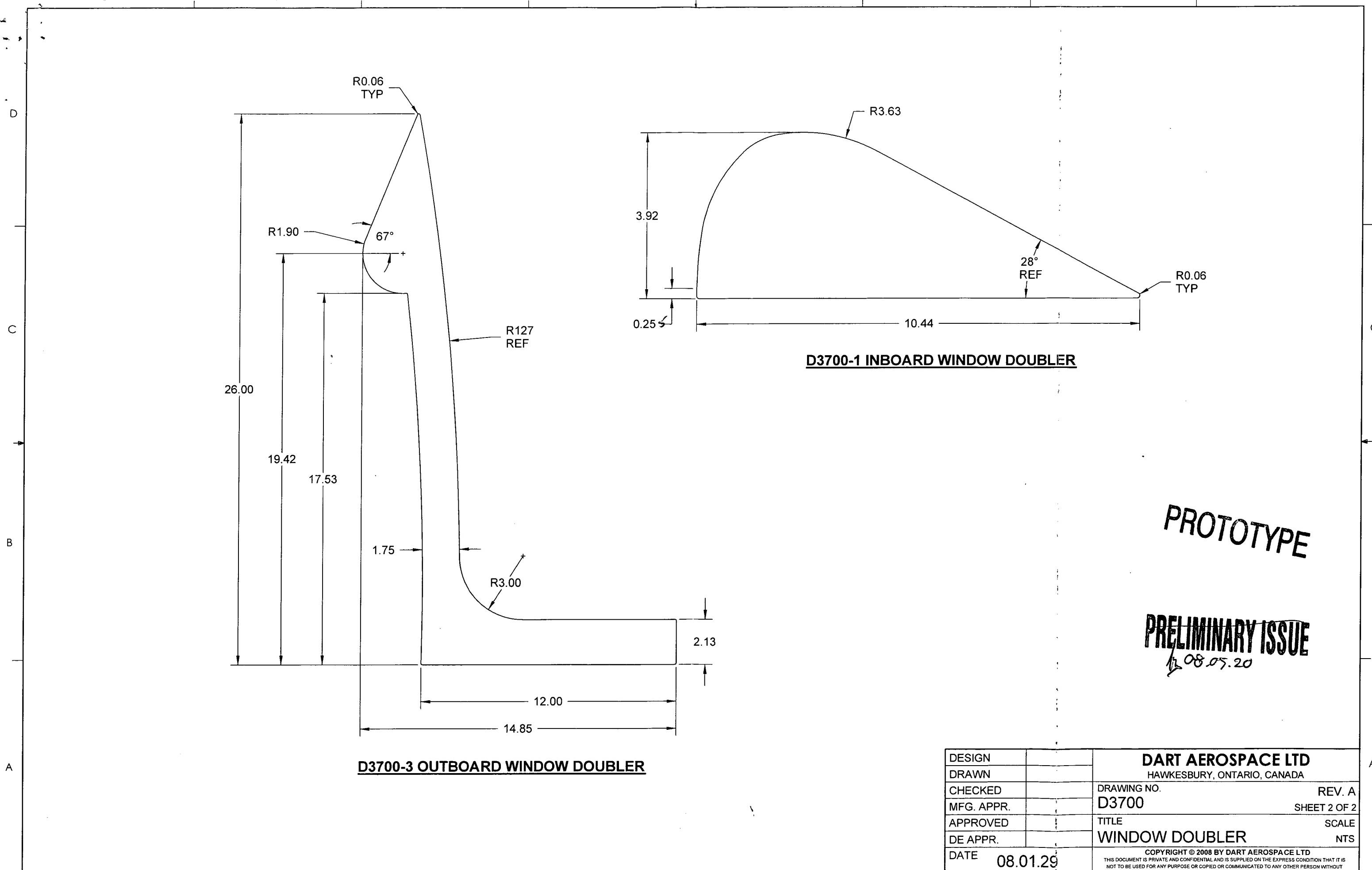
PRELIMINARY ISSUE
1080520

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3700-1 = 0.20 lbs
D3700-3 = 0.45 lbs

A	NEW ISSUE	MB	08.01.29	
REV.	DESCRIPTION	BY	DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	
MFG. APPR.			D3700	REV. A
APPROVED		SHEET 1 OF 2		
DE APPR.	1	TITLE		
DATE	08.01.29	SCALE	NTS	
		COPYRIGHT © 2008 BY DART AEROSPACE LTD		
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1



DART AEROSPACE LTD	Work Order:	38828
Description: INBOARD WINDOW DOUBLER	Part Number:	D3700-1
Inspection Dwg: D3700-1 Rev: D.R.F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:		Prototype Approval:	HB
Date:	8-5-25	Date:	080525	Date:	08.05.25

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Receiving Report

Date:	<u>8/5/22</u>
Supplier:	<u>CJ M&R</u>
Packing Slip:	Yes <input checked="" type="checkbox"/>
Invoice:	Yes <input type="checkbox"/>
Discount:	Cash <input type="checkbox"/>
	No <input type="checkbox"/>
	No <input type="checkbox"/>
	Cr <input type="checkbox"/>

Batch No: M01709
Dart P/O: 6/91

Release Note Attached: Yes ✓ No ✓ N/A ✓
Waybill Attached: Yes ✓ No ✓ N/A ✓
Shipment Complete: Yes ✓ No ✓ N/A ✓
QC6 Inspection ✓ ✓ ✓ N/A ✓
Work Order

Initials of receiver (if shipment OK) Level 12 LL

Production/Admin: 08/105/06
Date: 08/105/06
Received/Costing Initial: 781

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

7-4248
7-5696

MONTRÉAL : 514 336-4248
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

SHIP TO:

PACE LTD
EEN STREET

FACTURE INVOICE	N°	188898
DATE	02/05/08	
BON DE LIVRAISON PACKING SLIP	N°	134253
DATE DE LIVRAISON DELIVERY DATE	02/05/08	

TERMES / TERMS NET 30 JOURS		TERR. 2R	REMARQUES / REMARKS		PAGE N° 001
SCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT	
3/4	36	365.000	CLB	C \$ 133.16	
080 X 144"	192	5.950		1142.40	
3/4	4	350.000	CLB	C \$ 15.47	
HARGE	1	3.950	UN	- 20	3.95
MAY 20 2008					
	POIDS TOTAL TOTAL WEIGHT	233			Formplus N° 86

11. HALS REMAIN THE PROPERTY OF "ACIER CAMP INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHEI-
12. BUYERS EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
13. I RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTED TO PAY
14. PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT OF PAY-
15. MENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
16. D.O.D. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE
17. OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND A
18. CHARGE.

N BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

SOUS-TOTAL	1294.98
SUB TOTAL	
T.P.S.	64.75
G.S.T.	
T.V.Q.	0.00
Q.S.T.	
<big>TOTAL</big>	1359.73

CLIENT / CUSTOMER'S SIGNATURE

DATE

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material and the composition limits and had the mechanical properties shown on this face of this sheet.

Per:

Mack J. Vrablic

Mack J. Vrablic
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

Page 1

876767 0
Ship Date B.L. No.
2008-01-16 2726230
P.O. No./Contract No. Customer
CMMPO19 Contract 110

Invoice No. Alcoa No. Item
00000 4977123-3

Mfg. Order

N20523

Ship To:

Item Description
0.08 IN TK (+0 -.0045) X 48.0 IN W (.046875 -.046875) (IN) A/T 6061-T6 COIL SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-250/11 AMS4027 REV M IS 2007 ASTMB209 REV 07 CMMPO19 REV D CMMPO25 REV Q CSTI008 REV D ((NOT MARKED)) LIGHTLY CILED COIL SIZES:
ID 20 IN COIL WTGS: MAX 5750 LB MAX GROSS
SKID WTG: 6000 LB QUAN TOL +/-30 %
CQR 0211084 REV 02 CUST REQ 08-01-19 *** W/E 08-01-26 ***

Num	Package	Ticket	Lot	Weight	Quantity	UOM	Pc Id/Ser#
1	603327		493536	4363	1	PC	:
2	603424		493536	4391	1	PC	:
				8754	2		

Notes for CQR: 0211084.2
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PROD DCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.
Exception to Spec CMMPO19 : Revsn: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL .
Exception to Spec CMMPO25 : Revsn: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B. .
Exception to Spec CSTI008 : Revsn: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL .

CQR: 0211084.2 -Specification Limits -----

Temp	Dir	UTS			TYS			EL40D		
		Max	KSI	KSI	Max	KSI	KSI	Min	PCT	
T6	Long Transv.	Max					42.0	35.0	10	
		Min								

Chemical Composition	Other Other									
	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Each	Total Aluminum
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Min	0.40		0.15		0.8	0.04				REMAIN

Alloy 6061 - Mechanical, Physical, Metallurgy, Quantometer Results -----

Temp	Dir	No->			UTS			TYS			EL40D		
		Test	KSI	KSI	Test	KSI	KSI	Test	PCT				
T6	Long Transv.	2	50.2	45.3	11	50.6	45.3	11.4					

CERTIFIED INSPECTION REPORT

Alcoa Inc.

We hereby certify that the material covered by this certificate has been inspected and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Mark J. Vitale
Director of Manufacturing Davenport Works

Karen P. Young
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

Page 2

Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
876767 2008-01-16	0 2726230	00000	4977123-3
P.O. No./Govt Contract No.		Customer	Mfg Order
		SAMUEL SON & CO LT DCE-77123-3	
N20523			

Lot: 493536 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----

Cast Number	Chemical	Si	Fe	Cu	Mn	Hg	Cr	Zn	Ti
H310506A	Actuals	0.62	0.4	0.25	0.06	1.0	0.19	0.03	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States